Work Order ID 112078

January-29-14 8:58:10 AM

112078

Item ID: D4635-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Fwd Ceiling Panel, LH

Start Date: 30/01/2014 **Start Qty:** 1.00 *1*

Required Date: 24/02/2014 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** AH **Date:** 14-01-29 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D4635 / E									
100		0.00							
100	HAND FINISHING THERMOFORMING					x1			DH 14/02/04
Thermoform	**Memo**	0.00							
Thermoforming Machine	Cut Blanks								
105		0.00							
105	Dry Material					x1			DH 14/02/04
HandThermo	**Memo**	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								

Temp: 245 deg. F

Time IN: 5:00 PM 6:00 AM FEB 04 2014

Time OUT: _____ Per DH

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4635-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd Ceiling Panel, LH
Start Date: 30/01/2014 **Start Qty:** 1.00 *1*
Required Date: 24/02/2014 **Req'd Qty:** 1.00 *1*
Reference: **Cust Item ID:** **Customer:**

Approvals: **Process Plan:** 1 **Date:** **Tooling:** **Date:** **Run Start** *NR1*
QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	THERMOFORMING MACHINE								
Thermoform	**Memo**	0.00				X1			DL 14/02/24
Thermoforming Machine	Thermoform as per Dwg. D4635-1 and Folio FTA147								
	Dwg. Rev. E								
	Folio Rev. D								
	Visually inspect for proper formation and texture								
130		0.00							~~DAS 07 9-89~~
130	HAND FINISHING THERMOFORMING					X1			14/03/24
Thermoform	**Memo**	0.00							
Thermoforming Machine	Trim to Finished Dimensions								
140	QC6- Inspect dimensions to drawing	0.00							
140	Dimensional Inspection								
QC	**Memo**	0.00							
Quality Control	Fill out Inspection Sheet Rev A								

SMP 14/3/24

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Set-up
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☐ Other

Item ID: D4635-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd Ceiling Panel, LH
Start Date: 30/01/2014 **Start Qty:** 1.00 *1*
Required Date: 24/02/2014 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	**Memo**	0.00 N/A SM							
Quality Control									
160		0.00							
160	Packaging	med Fab				(1) SAD	14/03/24		
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	**Memo**	0.00				MLS	14-03-25		
Quality Control									

MLS 14-03-24

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

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☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Picklist Print

January-29-14 8:58:22 AM

Work Order ID: 112078

112078

Parent Item: D4635-1

D4635-1

Parent Item Name: Fwd Ceiling Panel, LH

Start Date: 30/01/2014 **Required Date:** 24/02/2014

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 12/11/08 DL IPP Rev. C Dwg Update 13/07/09 DL IPP Rev D Dwg Update, Material Change 14/01/20 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,385.760	14.9	15			

MLEXS.093-F6006-07

GE PLASTICS LEXAN SHEET

**

Location	Loc Qty	Loc Code
MAT023	1385.76	
114459	229.26	
123105	38	
124501	1118.5	

15 ~~30~~ 1

14/02/07

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Doc/Data	☐									
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Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

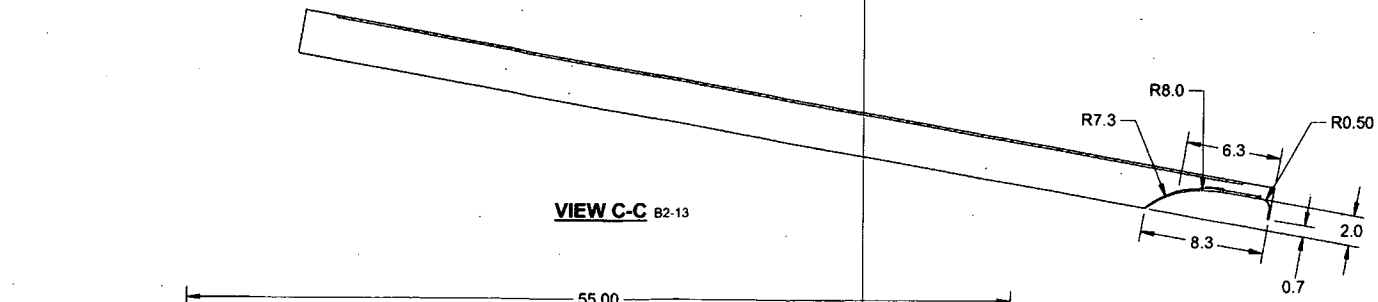
FAULT CATEGORY

Landing Gear

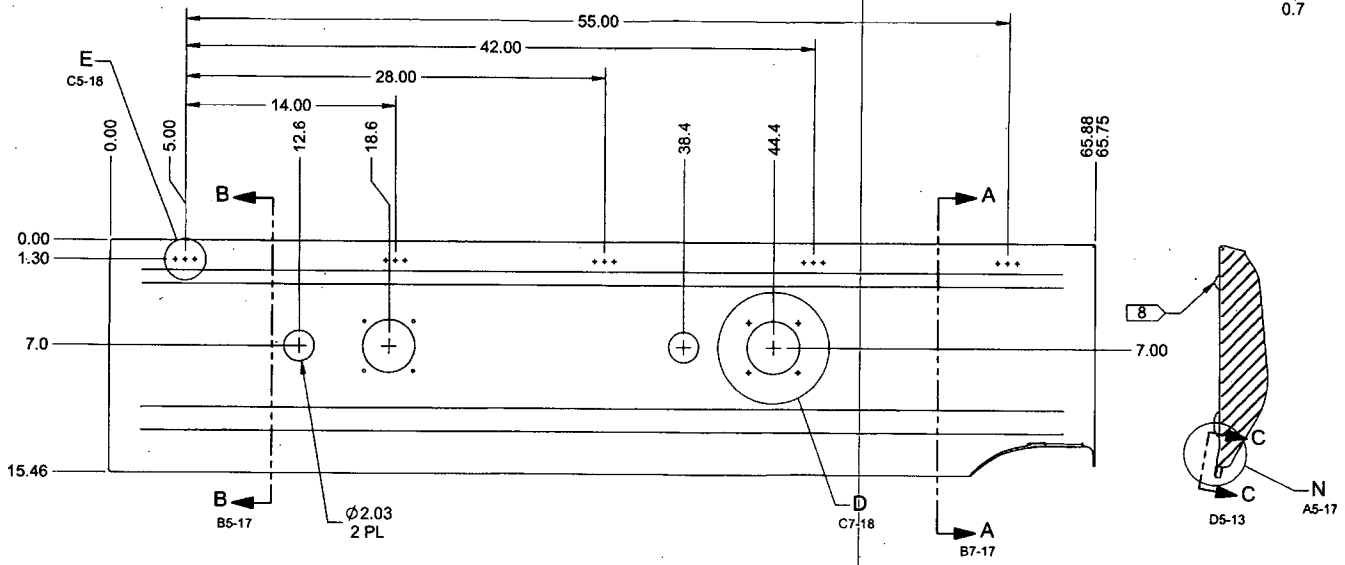
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other



VIEW C-C B2-13



112078 AP
14-01-29

RELEASED
Date 2014-01-22
AP

NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.39 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-1 PER TOOL DT9839
10) THERMOFORM D4635-1 PER QSI 022 USING DT9847 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

D4635-1 LH, FWD CEILING PANEL

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4635 REV. E
MFG. APPR.		SHEET 13 OF 18
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
DATE 14.01.09		

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
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Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

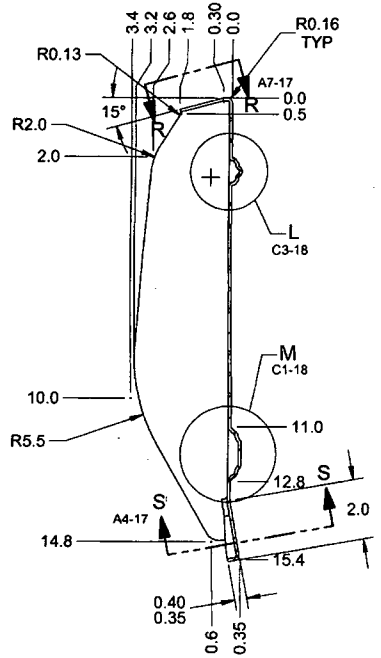
FAULT CATEGORY

Landing Gear

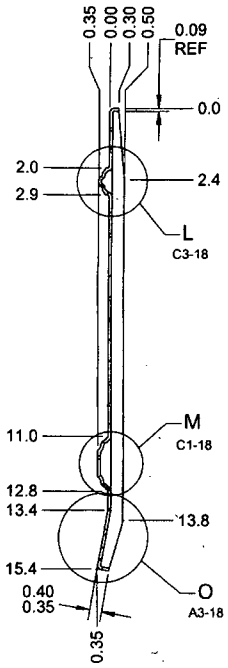
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☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
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General

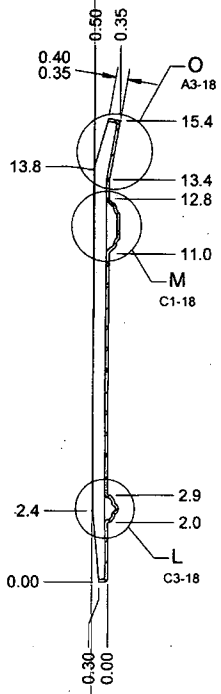
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☐ Other



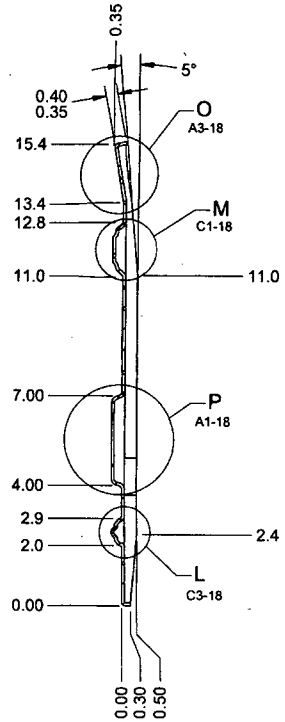
SECTION A-A
SECTION A'-A' OPPOSITE B3-13 B3-14
SCALE 2X



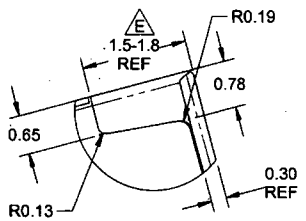
SECTION B-B B7-13 B7-14
SCALE 2X



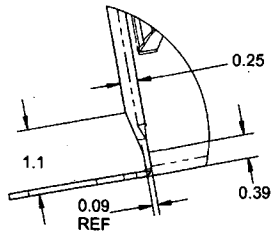
SECTION G-G B4-15 B4-16
SCALE 2X



SECTION K-K C6-16
SCALE 2X



AUXILIARY VIEW R-R D7-17
SECTION R'-R' OPPOSITE
SCALE 2X



AUXILIARY VIEW S-S B7-17
SECTION S'-S' OPPOSITE
SCALE 2X

RELEASED
2014 -01- 22

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D4635 REV. E
MFG. APPR.		SHEET 17 OF 18
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

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Part No. _____

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DISPOSITION

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

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Doc/Data	☐									
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Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
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FAULT CATEGORY

Landing Gear

☐ Bending
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☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
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General

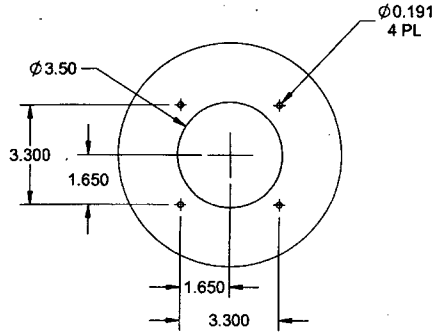
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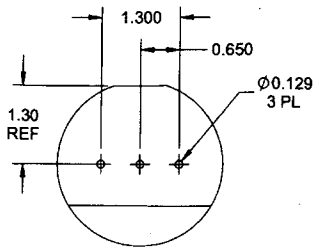
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
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☐ Pressure/Forced
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☐ Weld
☐ Wrong Stock Pulled

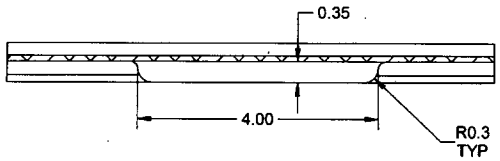
☐ Other



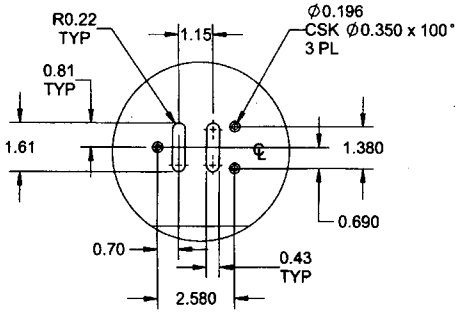
DETAIL D B4-13 B3-14 B5-15 B5-16
SCALE 2X



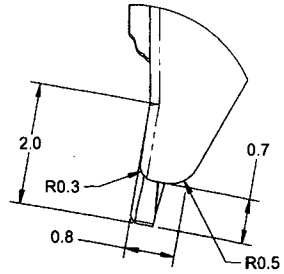
DETAIL E C7-13 B6-14 C5-15 B5-16
SCALE 4X



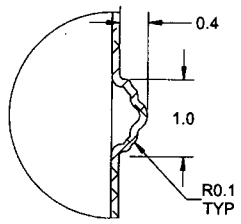
SECTION I-I B5-16
SCALE 4X



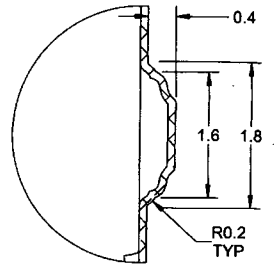
DETAIL Q C5-16
SCALE 2X



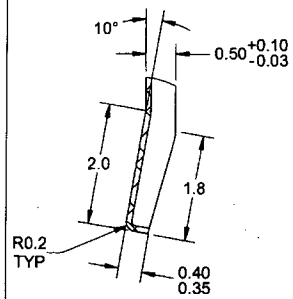
DETAIL N B2-13
SCALE 2X



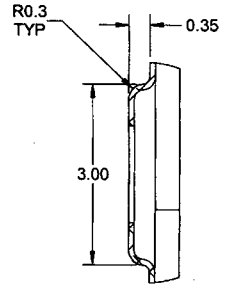
DETAIL L B2-17 B4-17 C5-17 C7-17
SCALE 1.5X



DETAIL M C2-17 C3-17 C5-17 C7-17
SCALE 1.5X



DETAIL O D2-17 D3-17 B5-17
SCALE 2X



DETAIL P C2-17
SCALE 4X

RELEASED
2014 -01- 22

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D4635 REV. E
MFG. APPR.		SHEET 18 OF 18
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- ☐ Rework
- ☐ Scrap
- ☐ Use-as-is
- ☐ Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

- ☐ Skid-tube
- ☐ Machining
- ☐ Thermoforming
- ☐ Large Fab
- ☐ Crosstube
- ☐ Small Fab
- ☐ Finishing
- ☐ Composite
- ☐ Water Jet
- ☐ Prod. Eng. Coor.
- ☐ Rec/Store/Packaging
- ☐ Supplier
- ☐ Engineering
- ☐ Quality
- ☐ Other
- ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

DART AEROSPACE LTD

Description:	Fwd Ceiling Panel LH	**Work Order:**	112078
Inspection Drawing:	4635-1	**Rev:** E	**Part Number:** D4635-1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.00	+/- 0.030	14.00	✓		tape	SFAB-21
28.00	+/- 0.030	28.00	✓		↓	↓
42.00	+/- 0.030	42.00	✓		↓	↓
55.00	+/- 0.030	54.00	✓		↓	↓
7.0	+/- 0.100	7.0	✓		↓	↓
12.6	+/- 0.100	12.6	✓		↓	↓
18.6	+/- 0.100	18.6	✓		↓	↓
38.4	+/- 0.100	38.4	✓		↓	↓
44.4	+/- 0.100	44.4	✓		↓	↓
5.00	+/- 0.030	5.00	✓		↓ tape	SFAB-21
Ø3.50	+/- Ø0.010	3.50	✓		vern	SFAB-08
3.300	+/- 0.010	3.300	✓		↓	↓
3.300	+/- 0.010	3.300	✓		↓	↓
Ø0.191	+/- 0.005 -0.001	0.191	✓		↓	↓
Ø0.129	+/- 0.005 -0.001	0.129	✓		↓	↓
Ø2.03	+/- 0.002 -0.001	2.03	✓		vern	SFAB-08

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
SAD	SM		
Date 14/03/24	Date 14/3/24	Date	Date

636-2082

H:\FORMS\Quality Assurance\approved QA\Inspection sheet revA